

Work Order ID 160055

Thursday, April 20, 2017 12:58:15 PM

160055

Page 1

Item ID: D3646-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm

Start Date: 4/20/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/27/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED/S

Approvals:

Process Plan:

DAS
21
9-88

Date:

APR 20 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3646

Rev C

100

0.00

100

NC BRAKE

Brake NC

Memo

0.70

Brake NC

1-Punch to length as per Dwg D3646 & template DT8959

4 FF APR 21 2017

110

0.00

110

Small Fab

Small Fab

Memo

0.78

Small Fab

1-Deburr2- Bend as per dwg D3646

4 FF APR 21 2017

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.08

Quality Control

4 FF APR 24 2017
DAS
38
9-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 160055***160055***

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Item ID: D3646-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm
Start Date: 4/20/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/27/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 136370</i> Memo START TIME: <i>1:35</i> <i>8:30</i> FINISH TIME: <i>2:05</i> OVEN TEMPERATURE: <i>34 9-89</i>	0.00 0.29				<i>H</i>	<i>Φ 17-04-20</i>	<i>34 9-89</i>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<i>4</i>		<i>DAS 38 9-89</i>	<i>APR 26 2017</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>S3571</i> Memo	0.00 0.04				<i>4</i>		<i>DAS 6 9-89</i>	<i>APR 28 2017</i>

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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

MAY 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 160055

160055

Parent Item: D3646-3

D3646-3

Parent Item Name: Arm

Start Date: 4/20/2017

Required Date: 4/27/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A new issue 07.07.25 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	31.9928	2.91	12.25263			

M304TR0 500W 035

304 RD Tube .500 x .035W

FF

APR 21 2017

Location

Loc Qty

Loc Code

GA

31.992796

m137086

24.165477

m137199

2.300579

m137286

5.52674

12.25263

DQA: _____ Date: _____

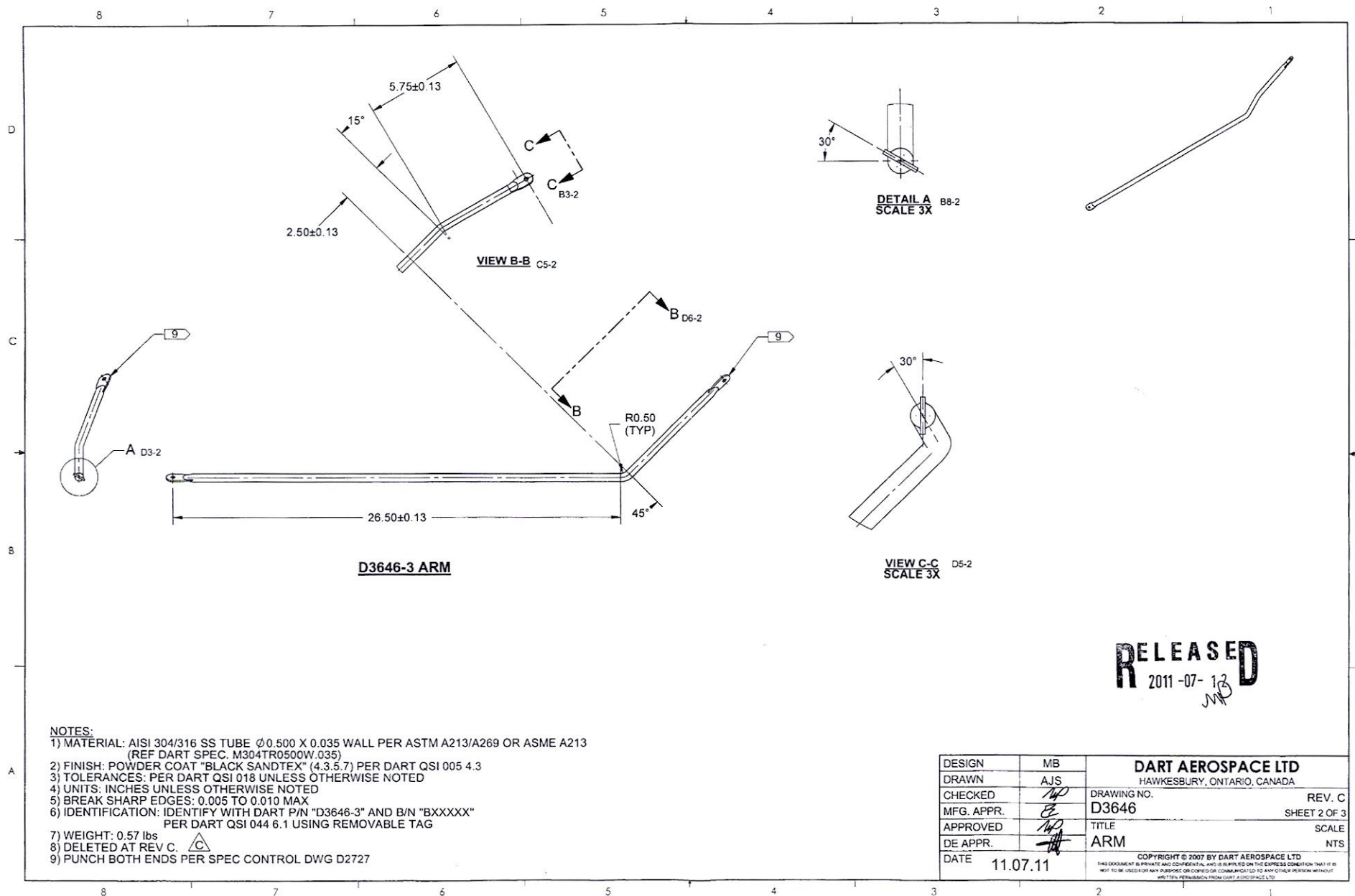


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RELEASED
 2011-07-13
[Signature]